

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. D
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-742 REV. 3

REF. CANADIAN STC: SH05-37

REF. FAA STC: SR01583SE

REF. EASA STC: EASA.IM.R.S.01126

PURPOSE:

The purpose of this service instruction is to provide instructions to replace the stainless steel NAS1330S3KB inserts used to attach the wearplates with cad-plated steel AEELS-1032 inserts. Instructions are also provided for the removal of LPS-3 corrosion inhibitor.

PROCEDURE:

- 1) To remove LPS-3 from the interior of the skidtube, use LPS A-151 Cleaner/Degreaser per the manufacturer's instructions.
- 2) To replace NAS1330S3KB inserts with AEELS-1032 inserts, perform the following:
 - (a) Remove the skidtube from the aircraft and disassemble the fwd / aft skidtube sections and wearplates per ICA-D412-742.
 - (b) Drill out the existing wearplate inserts.
 - (c) Counterbore indicated holes per Figures 1-3 and Table 1 of this service instruction using Ø7/16" c'bore bit with Ø1/4" c'bore pilot.
 - (d) Open holes with Ø19/64" drill bit (Ø0.297").
 - (e) Touch up holes with chemical film (Alodone 1200 or 1201) per MIL-C-5541.
 - (f) Install AEELS-1032-XXX inserts per Figure 1-3 and Table 1 of this service instruction.
 - (g) Touch up paint finish with one coat of MIL-P-85582 or MIL-P-23377 primer and 2-3 coats of MIL-C-83285 polyurethane coat to match original finish.
 - (h) Reassemble and reinstall tube per ICA-D412-742.

The following replacement insert kits are available for the D412-742-011/-013 skidtubes:

QTY -041	QTY -011	QTY -013	QTY -015	PART NUMBER	DESCRIPTION
X				DSI-9475-041	INSERT REPLACEMENT KIT
1	X			DSI-9475-011	INSERT REPLACEMENT KIT (D3391-011/-021 FWD TUBE)
1		X		DSI-9475-013	INSERT REPLACEMENT KIT (D3391-013/-023 MID TUBE)
1			X	DSI-9475-015	INSERT REPLACEMENT KIT (D3391-015/-025 AFT TUBE)
2	20	14		AEELS-1032-130	INSERT
10		12		AEELS-1032-225	INSERT

A	NEW ISSUE		CP	09.08.12
REV.	DESCRIPTION		BY	DATE
DESIGN	qp	DART AEROSPACE USA, INC PORT HADLOCK, WA		
DRAWN	qp			
CHECKED	PA	DRAWING NO.	REV. A	
MFG. APPR.		DSI 9475	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		INSERT REPLACEMENT	NTS	
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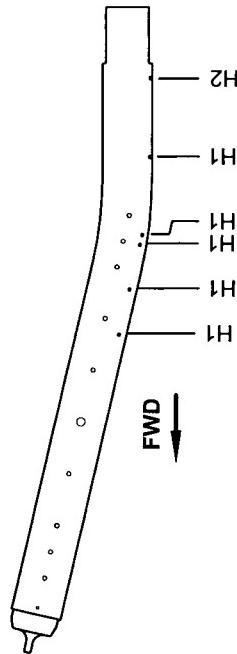


FIGURE 1: D3391-011/-021 FWD TUBE ASSEMBLY

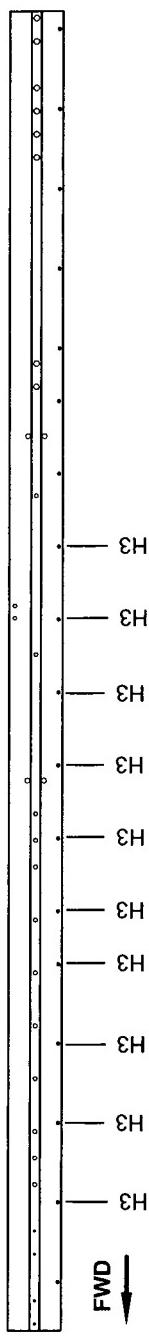


FIGURE 2: D3391-013/-023 MID TUBE ASSEMBLY

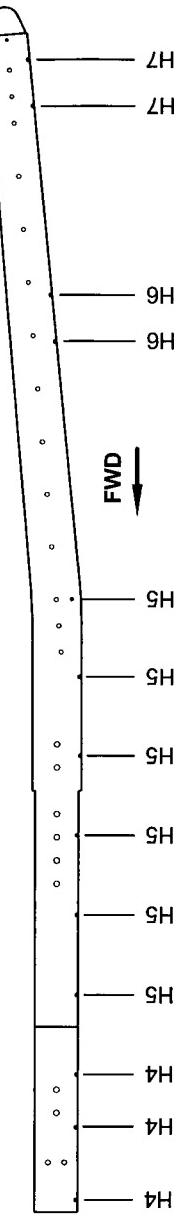


FIGURE 3: D3391-015/-025 AFT TUBE ASSEMBLY

TABLE 1

HOLE	C'BORE dia. x depth	DRILL SIZE	INSERT
H1	N/A	Ø0.297"	AELS-1032-225
H2	Ø0.438" x 0.040"	Ø0.297"	AELS-1032-130
H3	N/A	Ø0.297"	AELS-1032-130
H4	Ø0.438" x 0.040"	Ø0.297"	AELS-1032-130
H5	Ø0.438" x 0.170"	Ø0.297"	AELS-1032-225
H6	Ø0.438" x 0.170"	Ø0.297"	AELS-1032-130
H7	N/A	Ø0.297"	AELS-1032-130

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